

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-27 Date Opened: 03 Feb 17 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Low Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94610	0	Basket	JR
94627	0	Placard	JR
70405	4	Walkway	JR
84240	0	Lid Brace Install	JR
84255	2	Handle Install	JR
94621	0	Brace	JR

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JR
JR
JR
JR
JR
JR
JR

Work performed by:

Print: J. RekveSign: [Signature]SCA: AD01Date: 03-Feb-17

ICC / Dual Inspection preformed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 03-Feb-17

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 03-Feb-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	Tread Plate	
Aircraft:	All	Model: N/A
Description:	Lid Walkway Checker Plate	
Supplier:	Daigle Marine	
Color:	Aluminum	
WO#:	N/A	PO# 17011



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 94621-01

Aircraft: Bell

Model: 407

Description: Brace

Supplier: Aero Design

Color: N/A

WO#: 2015-121

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

1

MS20001P4-9600

All

Model: All

Hinge

Bisco Industries

N/A

WO#:

N/A

PO# 16030

2017-27

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket ✓

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway ←

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2017-27

Date Open: 03 FEB 2017

AD
73-04
01

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

AD
73-04
01

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??

AD
73-04
01

- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD
73-04
01

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

AD
73-04
01

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ?? . Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

AD
73-04
01

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

AD
73-04
02

NOTICE

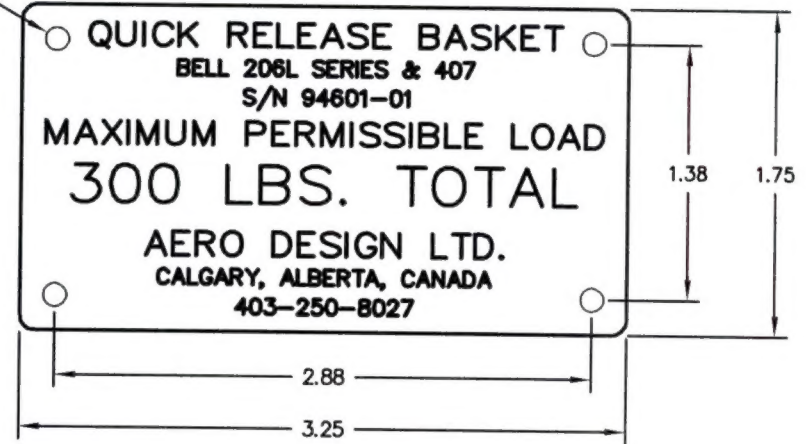
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 206L SERIES & 407" - 0.080 HIGH
 "S/N 94601-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
 "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES

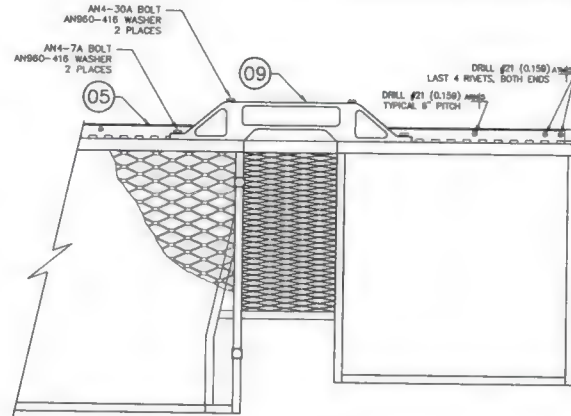


01 PLACARD

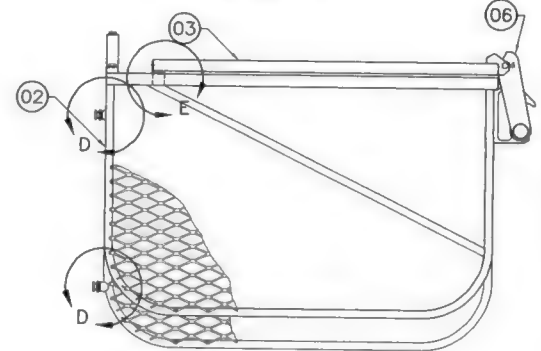
1	94627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	16 SEPT 2011		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A1	94627	0

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM DASH11, REV. 0		



VIEW B
LOOKING AT AFT INBOARD SIDE



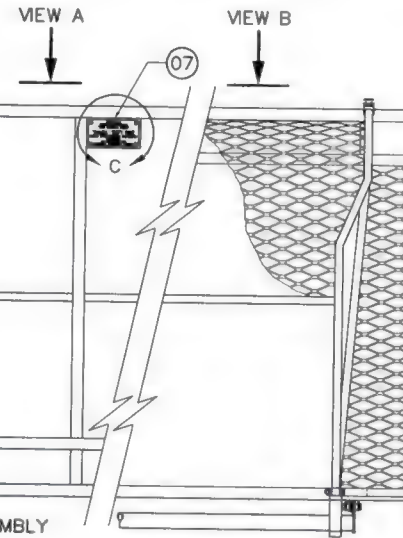
DETAIL D
SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL
4	AN860-416	WASHER		
2	AN4-30A	BOLT		
2	AN4-7A	BOLT		
A/R	AN860-816	WASHER		
4	40088-14	FITTING		ANCR
4	CR3213-4-02	CHERRY RIVET		
8	CR3523-5-02	CHERRY RIVET		
A/R	CR3213-5-02	CHERRY RIVET		
1	94621-01	BRACE		
4	46205-14	OB BUMPER		ARGUS INDUSTRIES
1	94627-01	PLACARD		
1	84255-01	OB HANDLE BAR INSTALLATION		
1	MS20001P4	OS PLANO HINGE		
1	36280-01	OB BRACE ASSEMBLY		
1	94612-01	OB LID ASSEMBLY		
1	94611-01	OB BASKET BODY ASSEMBLY		
1	94610-01	OB CARGO BASKET ASSEMBLY		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL

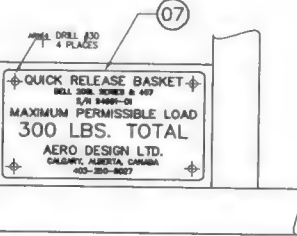
LIST OF MATERIALS

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVAL, DAR 8004
8013 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6P7
tel: (403) 880-8087 fax: (403) 880-8088 aerodesign@telusplanet.net

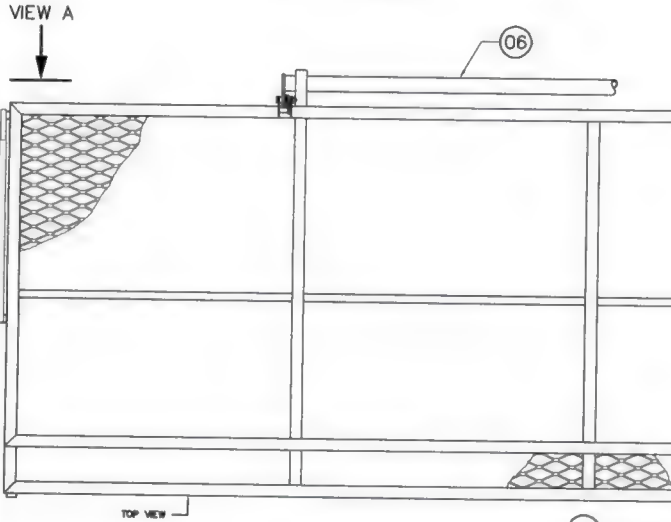
BELL 206L SERIES, 407
QUICK RELEASE CARGO BASKET
CARGO BASKET ASSEMBLY
SCALE 1 : 4
SHEET 1 OF 1
DWG. NO. 94610
REV. 0



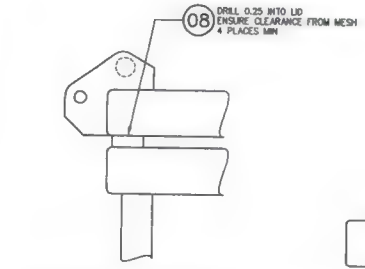
VIEW A
LOOKING AT FORWARD OUTBOARD SIDE



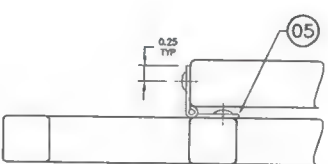
DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET



01 BASKET BODY ASSEMBLY



BUMPER INSTALLATION
SCALE 1 : 1



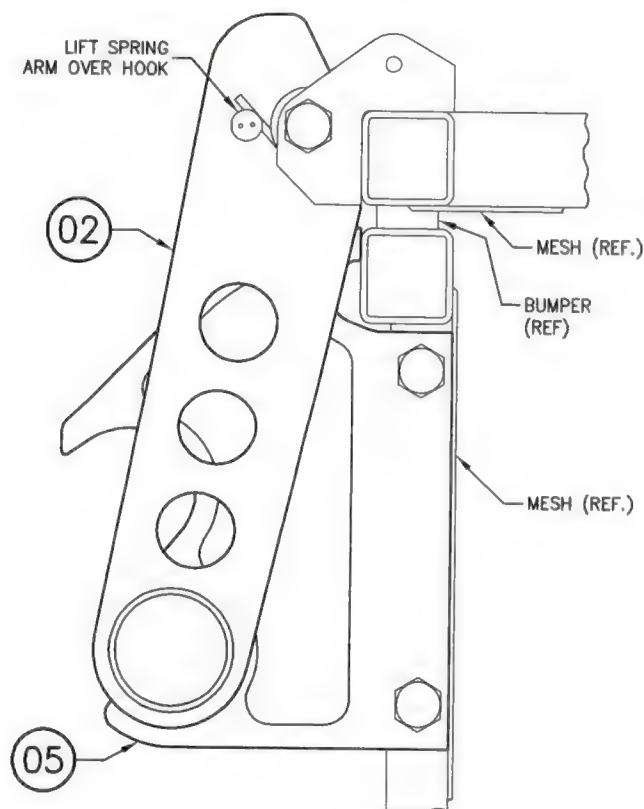
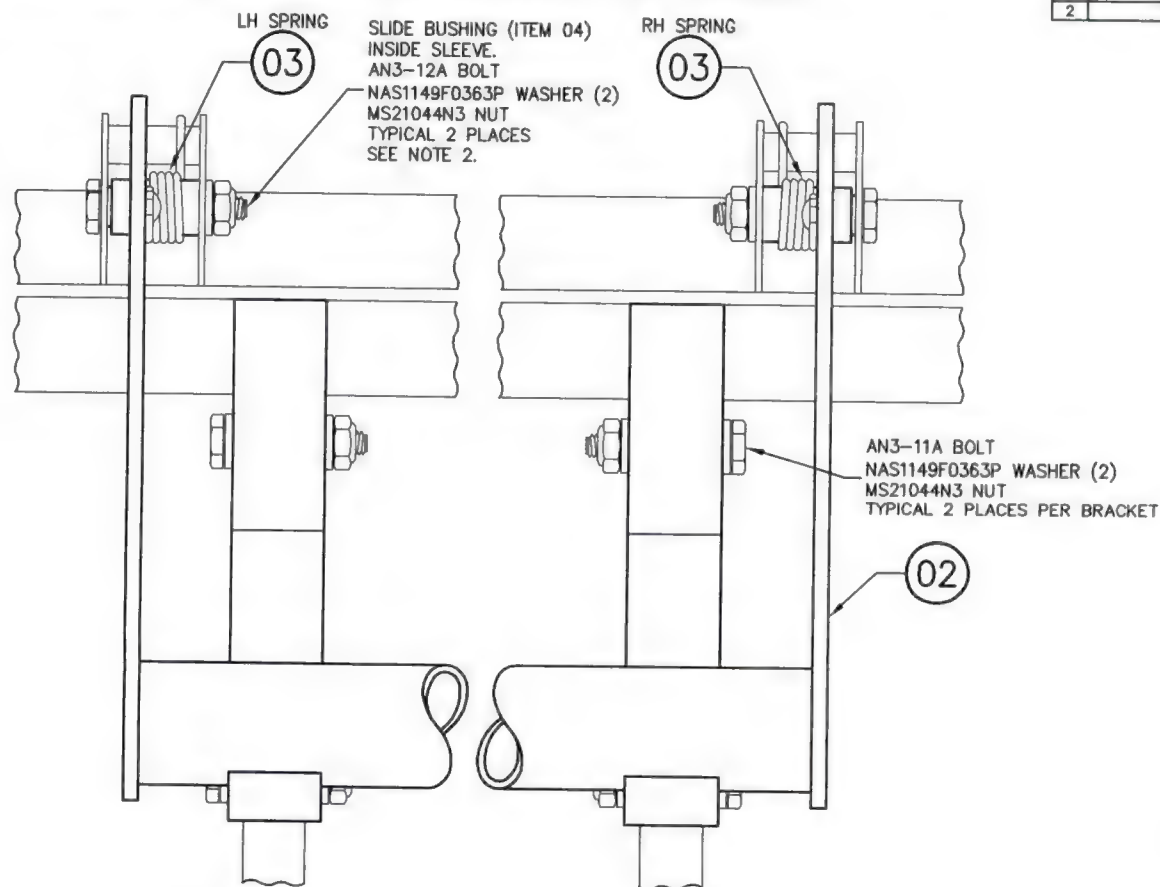
DETAIL E
SCALE 1 : 1
LOOKING AT HINGE

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. HAS 523	H=HDD, HEAD NEAR SIDE F=HDD, HEAD FAR SIDE	GRABER: JEFF CLARKE CHECKED: E. BURGON	24 OCT 2011
C=COUNTERSUNK D=DMPL DQTY=# OF SHEETS TO BE DMPLD	DASH NO. FOR LENGTH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
		DECIMALS	ANGLES
		X.XXX ±0.010	±1/2°
		X.XX ±0.03	
		X.X ±0.1	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARW=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE -- CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-8132ZF
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	



AERO DESIGN LTD.

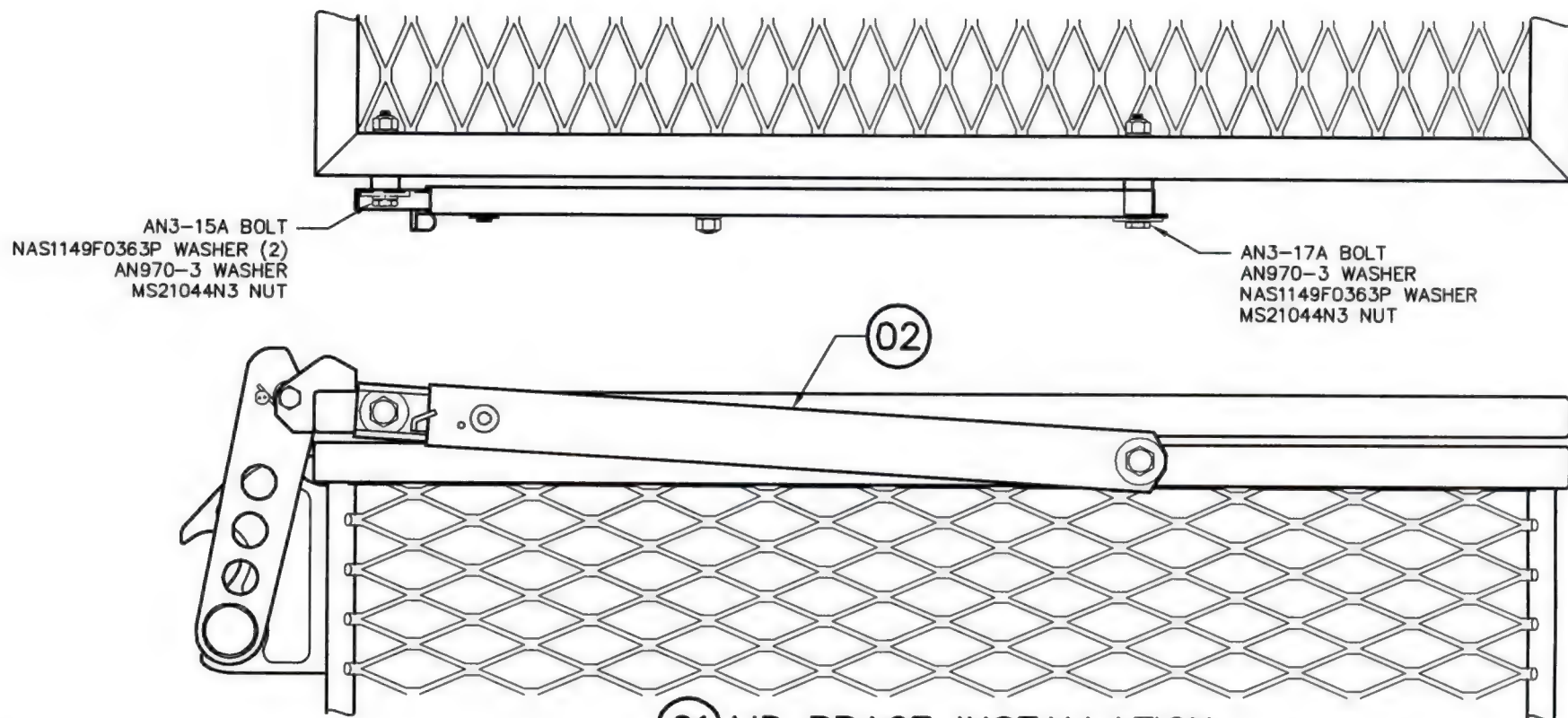
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



(01) LID BRACE INSTALLATION

NOTES

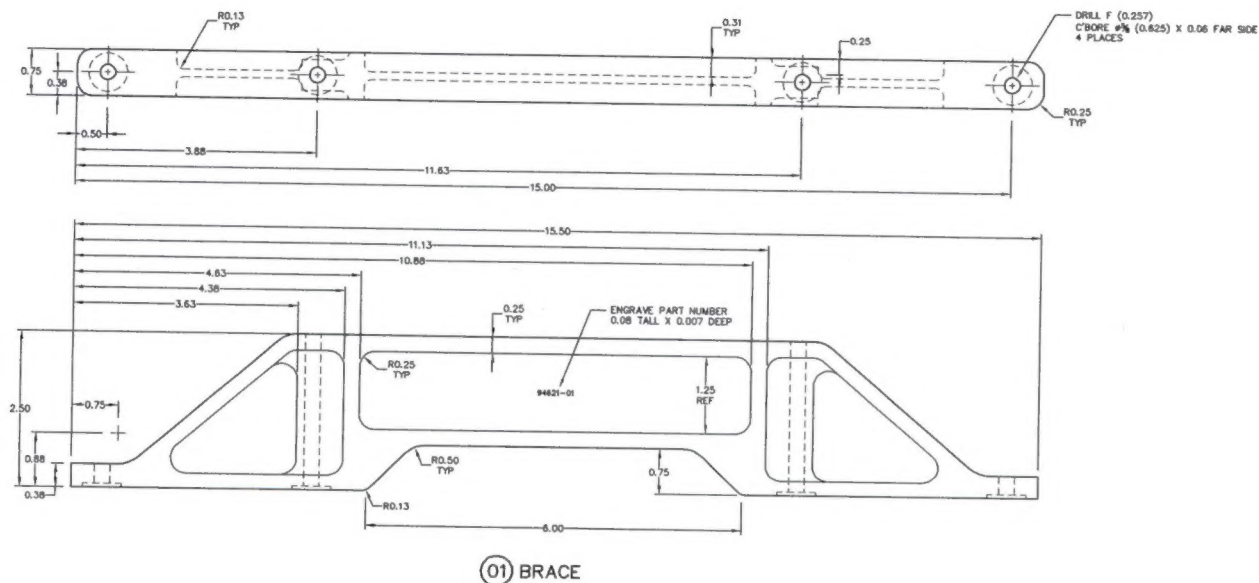
- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT	APPROVALS	DATE		AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.8376 www.aerodesign.ca			
3	NAS1149F0363P		WASHER	DRAWN: JEFF CLARKE	21 MAY 2014					
2	AN970-3		WASHER	CHECKED: JASON REKVE	21 MAY 2014					
1	AN3-17A		BOLT							
1	AN3-15A		BOLT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION				
1	36280-01	02	LID BRACE ASSEMBLY							
	84240-01	01	LID BRACE INSTALLATION							
01	PART NO.	ITEM	DESCRIPTION							
QTY.	LIST OF MATERIALS					NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.	
						SHEET 1 OF 1	A4	84240	0	

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0072
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-27
6. Item 1.	7. Description Cargo Basket	8. Part Number 94610-01	9. Qty. 1	10. Serial/Batch No. 94601-17	11. Status/Work New
12. Remarks Modified with Lid Walkway IAW DCL704, Red					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mm/yyyy) 03 Feb 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

Lohman Helicopters

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, PRIME, AND PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ALUMINUM PARTS TO BE ANODIZED IN ACCORDANCE WITH MIL-A-8625F, TYPE III, CLASS 1

4	94621-02	02	INSERT	1018 MILD STEEL	AISI 1010/1020	0.375 ROD
1	94621-01	01	BRACE	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 0.75 BAR
PART NO.		ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY			LIST OF MATERIALS			
			<div><div>APPROVALS</div><div>DATE</div></div> <div><div>DRAWN: JEFF CLARKE</div><div>25 OCT 2011</div></div> <div><div>CHECKED: E. BURGOIN</div><div></div></div> <div><div>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1</div></div>			
			<div><div><div><div>AERO DESIGN LTD.</div><div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 36TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 850-9087 fax: (403) 850-9393 www.aerodesign.ca</div></div></div><div><div>REL 2081 SERIES, 407 QUICK RELEASE CARGO BASKET BRACE FABRICATION</div></div></div>			
			SCALE 1 : 1		DWG. SIZE	DWG. NO.
			SHEET 1 OF 1		A1	94621
					REV.	0

Work Order: 2017-27Material Tracking Sheet
Bell 206L / 407

1 of 2

Date Opened: 03 Feb 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94610-01	Cargo Basket Assembly	<i>S/N 94601-17</i>	
Step 1				<i>Lid Assembly</i>		
	. 1		94612-01	Basket Lid Assembly	<i>2017-04</i>	<i>See kit PDS dkk</i>
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	<i>See PDS</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		94627-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	. . 4		CR3213-4-02	Cherry Rivet		<i>16042</i>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>17011</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>16042</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		94611-01	Basket Body Assembly		<i>2017-06</i>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<i>See PDS</i>
	. . 8		NAS1149F0663P	Washer		<i>See PDS</i>
Step 2.b.	. 1		90621-01	Brace		<i>2015-121</i>
	. 2		AN4-6A	Bolt		<i>15031</i>
	. 2		AN4-30A	Bolt		<i>14018</i>
	. 4		NAS1149F0463P	Washer		<i>16080</i>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<i>16030</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>16003</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>16042</i>

Work Order: _____

Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4	. 1	84255	84255-01	Handle Installation		
Step 4.a.	. 2		84267-01	Bracket	Delrin, 3/4" Sheet	2016-37
	. 4		AN3-11A	Bolt) See PDS
	. 8		NAS1149F0363P	Washer		
	. 4		MS21044N3	Nut		
Step 4.b.	. 1		84261-01	Handle Assembly		2017-18
	. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire) See PDS
	. 2		36275-01	Bushing	Brass, 5/16" Dia	
	. 2		AN3-12A	Bolt		
	. 4		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2016-145
	. 1		AN3-15A	Bolt) See PDS
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	



WO# 2017-27

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013